

Date: Monday, 16/03/2009 9:17:24 AM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	EC 135 SKIDTUBE ASSEMBLY
<b>Job Number</b> :	46502		
<b>Estimate Number</b> :	12472		
<b>P.O. Number</b> :		<b>Part Number</b> :	D135751011
<b>This Issue</b> :	16/03/2009	<b>Drawing Number</b> :	D3507 REVC
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	C
<b>Previous Run</b> :	46501	<b>Material</b> :	
	<b>Type</b> :	<b>Due Date</b> :	31/03/2009
	SKIDTUBES	<b>Qty:</b>	1 Um: Each
<b>Written By</b> :			
<b>Checked &amp; Approved By</b> :	JUL 09-03-16		
<b>Comment</b> :	Est Rev:A 06-06-21 New Issue JLM Est Rev:B 06-12-18 As per Rev B JLM Est Rev:C 07-12-11 ECN 1036 as per revB DD Est Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



*Handwritten:* JLD 09/04/09



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D135-751-011 CHG001

*Handwritten:* 5 09/05/06

2.0	D2962150	3.540 Outer Tube, Extrut
-----	----------	--------------------------

Comment: Qty ~~1000~~ High(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion

*Handwritten:* B28672

*Handwritten:* DP 9-3-16

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. ~~Do not~~ open holes.

3- Deburr holes.

*Handwritten:* 09-03-16

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE

Bend tube as per program

on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

*Handwritten:* MB 09-03-16

*Handwritten:* 09-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 46502

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

2-Cut Aft end at VC using DT8185

3-Deburr ends

✱ 4-Drill Aft & Fwd Cap holes using DT8678

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with 3/16 cleco in Ground wire hole , then Pilot Drill all X-Bolt holes using 3/16" drill. \*\*\*\*DO NOT OPEN AFT CAP HOLES\*\*\*\*\*

7-Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

✱ 8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

9-Open holes section C-C to .375" and locate DT9431 using "T" pin & cleco.

10- Drill holes section G-G (DT9431)

11-Open Aft & Fwd Cap holes using .208" drill.

12-Bore out aft end of tube as per Dwg D3507 & Detail "B".

13-Open ground wire hole .297" section E-E

14-Deburr holes.

PTJ  
DTJ

85  
090423

PTJ

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S. S. 090423

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1


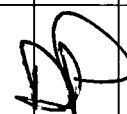


Comment: HAND FINISHING RESOURCE #1


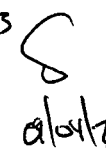

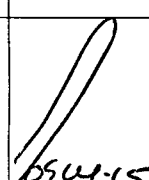
Chemical Conversion Coat as per QSI 005 4.1

85 09-04-24

# Dart Aerospace Ltd

W/O: 46502		ESTIMATE : 12472		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9-4-23	5	4- Should read Drill Aft & Fwd cap holes using DT8678 & DT8901				9-4-23		done 09/05/13	
9-4-23	5	8- <u>ADD</u> - Open to rear wearplate holes using DT8892				9-4-23			

Part No: D135-751-011 PAR #: N/A Fault Category: Prod / Skilled NCR: (Yes) No DQA: A Date: 09/05/14  
Resolution: Scrap Disposition: Scrap QA: N/C Closed: A Date: 09/05/14

NCR: 46502		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090316	5.2	Tube was cut too short. Should be 124.39; was cut too 124.2. 0.190" too short.  R.C: slack in measuring tape human error.		Eng would not pass the tube length. - scrap tube: same the material R is 105. Replace. <u>B 28672</u>	RT 09-04-23			

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Job Number: 46502

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D H 9-4-24

9.0

D35043

Crossbolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSBOLT SPACER

Batch: 31232

RT 09-04-28

10.0

D35041

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

Batch: 31234

RT 09-04-28

11.0

D35051

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Batch: 42531

RT 09-04-24

12.0

D35061

Doubler



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

DOUBLER

Batch: B46538

RT 09-04-28 (1)

13.0

D35063

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

Batch: B46539

RT 09-04-28 (2)

14.0

D35045

Crossbolt Spacer

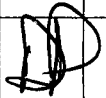


Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

batch 36181

RT 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9-4-23	5	10-Should read. Open holes to Section 6-6 as per DWG. Holes must be laid out manually.		9-4-23			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS20601AD4W3

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch: M107823

fm 09-04-28 (12)

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M11081

Exp Date: 10-01-01

ST 09-04-24

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: M110972

BE 09/04/28

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

> fm 09-04-28 (1)

Tools: E

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

807/04/28 (10)

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507.

fm 09-04-28 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46502

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/28 (X)

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BR 09-04-30 (R)

21.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(1)

START TIME:

11:05

OVEN TEMPERATURE:

320°

FINISH TIME:

11:35

FX 02/05/04

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-04

(X)

23.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch:

M1108606

Y1

24.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch:

M1110118

\* Y1

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

Y1 09-05-04 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46502

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

visual

507/05/04

27.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch

M1188062

\* 11

28.0

D29653

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B46582

11

29.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B329993

11 \*

PTU

30.0

D35081

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPLATE

Batch:

1342250 42973

11

31.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPLATE

Batch:

B42250

11

32.0

D35085

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPLATE

Batch:

B42251

11

09-05-04

PTU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D135-751-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 09/04/44  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>46502</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09-05-13</u>	<u>29.0</u>	<u>A D2465-3 read cap was installed onto the ASS'y.</u>	<u>[Signature]</u>	<u>Acceptable. this time only ensure to use the correct parts per W/O.</u>	<u>[Signature]</u> <u>09-05-13</u>	<u>[Signature]</u> <u>09-05-13</u>	<u>[Signature]</u>	<u>[Signature]</u>

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Job Number: 46502

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D35087

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 1344518

*ju*

34.0

D35581

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342533

*ju*

35.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1345661

*ju*

36.0

D35585

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1343244

*ju*

37.0

D35587

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1343245

*x ju*

38.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: 1110715

*x ju*

39.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: 1111424

*x ju*

09-05-04 *ju*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46502

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

NAS1611007

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

O-RING

batch:                      *u*

41.0

D3492041

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

PLUG ASSEMBLY

Batch: B45561 *jd*

42.0

D3492043

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

PLUG ASSEMBLY

batch: B46102 *x* *jd*

43.0

D3492047

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PLUG ASSEMBLY

Batch: B39722 *jd*

44.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total: 33.0000 Each(s)

Washer

Batch: M111424 *jd*

45.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total: 31.0000 Each(s)

BOLT

Batch: M111572 *jd*

46.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M111424 *jd*

04-05-04

*KT*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M111081

Exp Date: 10/20

3-Install Wearplates as per Dwg D3507 ,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Screws where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: M111081

Exp Date: 10/20

4-Install Plug assembly as per Dwg D3507.

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

M111013  
09-05-05

48.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/05

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

50.0

D35121

Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WEARPLATE

Batch: 44662

09/05/06

51.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M109632

09/05/06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46502

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

BATCH:

M 111572

8809105/06 (K)

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

80105/06 (K)

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751-011

Location:

PPP Rev:

82  
B

9/5/06

SP

55.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13 (K)

Job Completion



MF  
09-05-71

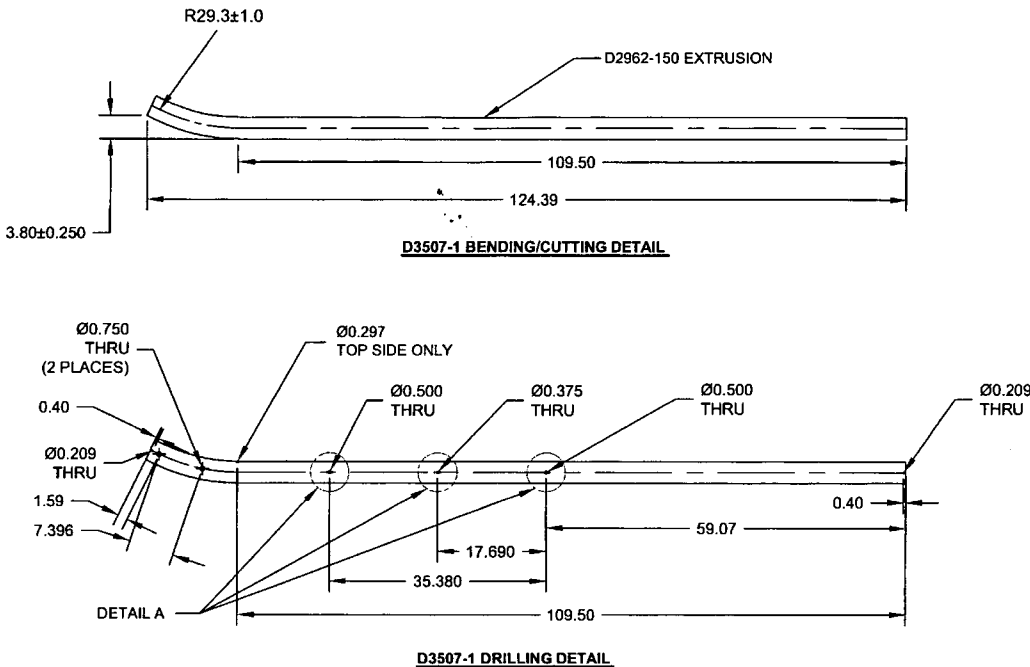
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

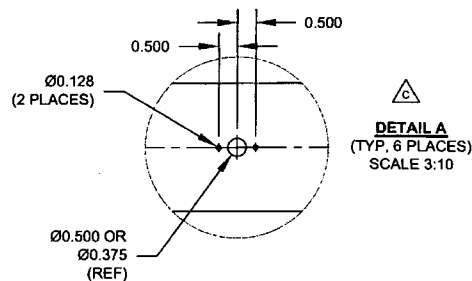
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3507-1 BENDING/CUTTING DETAIL**

**D3507-1 DRILLING DETAIL**



Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

**GENERAL NOTES:**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4.
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-2411-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	JIC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	EC	D3507	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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07.11.16.17

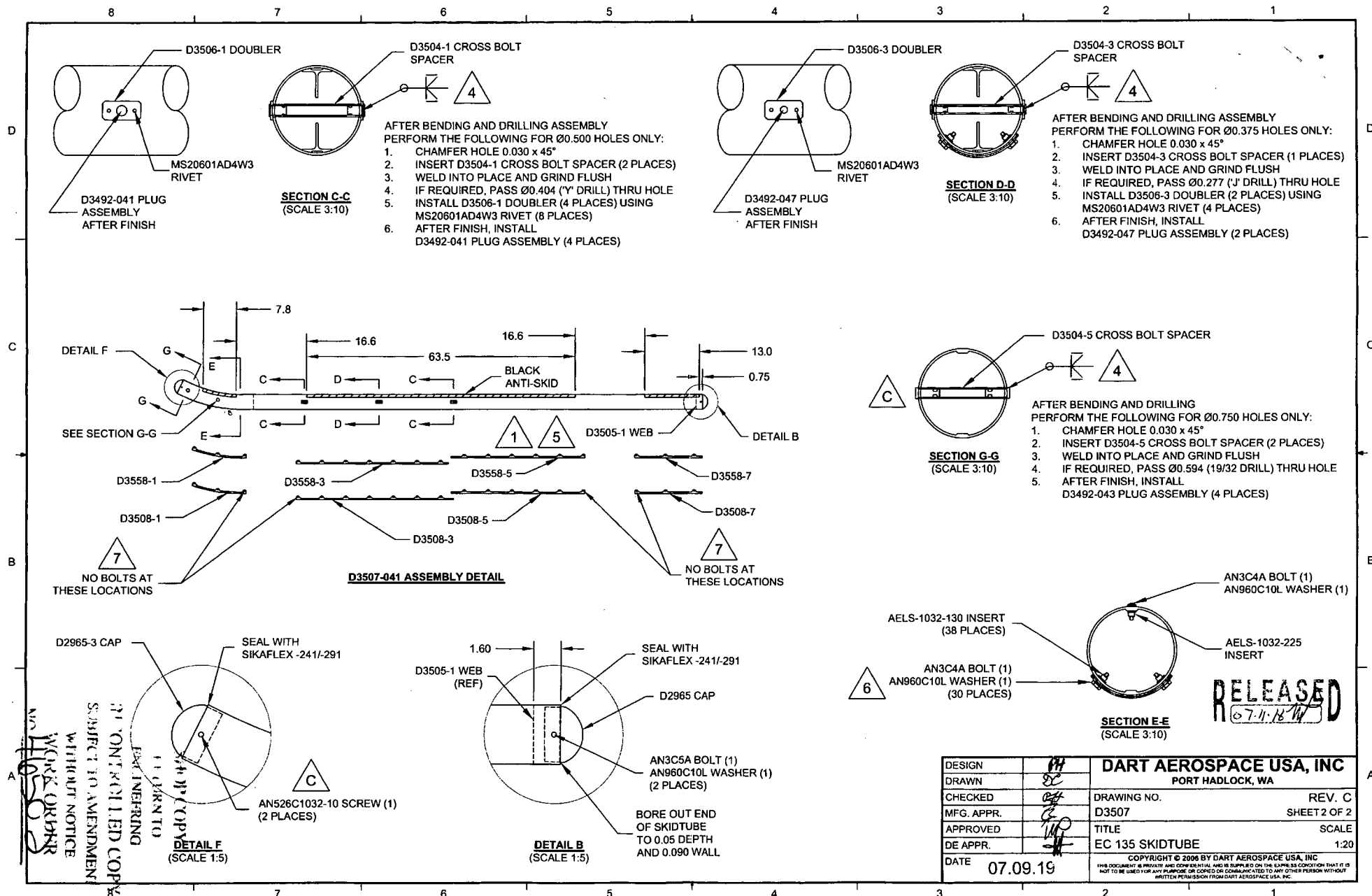
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries



NO. 179

**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name: Barclay Elliot  
Job number: 841333  
Part number: 135 751011  
Description: SKID tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks: pass[ ] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[ ] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Lunn Date of Test Coupon 08/10/22

Welder Barclay Elliot Date of Test Coupon 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld